

Work Order ID 77619

77619

Page 1

December-13-11 4:27:20 PM

Item ID: K10003 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Saddle, D205-634-011
 Start Date: 13/12/2011 Start Qty: 6.00
 Required Date: 05/01/2012 Req'd Qty: 6.00
 Reference: Cust Item ID:
 Customer:

Approvals: Process Plan: M.L.J Date: 11/12/13 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN634,635	Rev F								
100	DOCUMENT CONTROL	0.00							
100									
DC	Memo	0.00							
Document Control	Create White labels only per PPP K10003								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

MLJ 12-2-6
 (5)

SP 12-02-06

(5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77619

December-13-11 4:27:20 PM

77619

Page 2

Item ID: K10003 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle, D205-634-011
Start Date: 13/12/2011 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 05/01/2012 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: PK Memo	0.00 Revd 0.00				12/2/11	50		
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				12/2/11	50		

12-02-7
(5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December-13-11 4:31:37 PM

Page 1

Work Order ID: 77619

77619

Parent Item: K10003

K10003

Parent Item Name: Saddle, D205-634-011

Start Date: 13/12/2011

Required Date: 05/01/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: I 03.01.16 Reformat: Incorporated D205-641-011 KJ/RF
 IPP: J 06-07-25 As per DSI 9344 JLM
 IPP: K 06.11.17 Per K10003 Rev C KJ
 IPP: L 07.01.12 Document Record for copying bluefile rmv KJ
 IPP Rev: M 08-08-12 now @ chg 006 (DSI 9418) DD verified by:
 IPP N 09.01.27 DSI 9418 rev B EC verified by: DD IPP Rev: O
 11.03.11 per dsi9536 DD verf: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
S/P AN4-51A* Bolt		Purchased	No			110	Each	138.0000	8	48 40			
									**				
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST361			138					
					118706			50					
					119127			50					
					119798			38					
AN4-6A		Purchased	No			110	Each	4,130.000	16	26 80			
S/P AN4-6A* Bolt									**				
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST356			4130					
					119017			4130					
AN4C46A		Purchased	No			110	Each	36.0000	4	24 20			
S/P AN4C46A* BOLT									**				
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST360			36					
					119849			36					

SP
m/20/87 SP

~~30X~~

SP

80X

m/20334 20X SP
12-02-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December-13-11 4:31:37 PM

Page 2

Work Order ID: 77619

77619

Parent Item: K10003

K10003

Parent Item Name: Saddle, D205-634-011

Start Date: 13/12/2011

Required Date: 05/01/2012

Start Qty: 6.00

Required Qty: 6.00

AN6-12A Purchased No

110 Each 154.0000 8

48 40

AN6-12A

Bolt

**

SP

Location

Loc Qty

Loc Code

ST341

154

119934

154

AN960JD416 NAS1149D0463J Purchased No

110 Each 0.0000 32

AN960.ID416

Washer

**

10X

192 160

M119075

SP

AN960JD616 NAS1149D0663J Purchased No

110 Each 0.0000 8

AN960.ID616

Washer

**

48 40

M119075

SP

D2570 Manufactured No

110 Each 210.0000 24

D2570

Bushing

**

144 120

B78585 62x

SP

B78586 58x

58x

Location

Loc Qty

Loc Code

ST017

210

66933

1

67759

6

72122

1

72960

41

77421

161

D2571 Manufactured No

110 Each 8.0000 1

D2571

Saddle, Fwd Out 205

**

65

B78239

SP

12-02-06

Location

Loc Qty

Loc Code

ST425

-4

76438

8

ST433

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 3

December-13-11 4:31:37 PM

Work Order ID: 77619

77619

Parent Item: K10003

K10003

Parent Item Name: Saddle, D205-634-011

Start Date: 13/12/2011

Required Date: 05/01/2012

Start Qty: 6.00

Required Qty: 6.00

D2572

Manufactured No

110 Each 5.0000 1

D2572

Saddle, Fwd In 205

**

B 78237 5x SP

Location

Loc Qty

Loc Code

ST433

5

71107

2

76442

3

D2573

Manufactured No

110 Each 4.0000 1

D2573

Saddle, Aft Out 205

**

B 79424 5x SP

Location

Loc Qty

Loc Code

ST423

-12

ST434

16

76451

4

D2574

Manufactured No

110 Each 4.0000 1

D2574

Saddle, Aft In 205

**

B 78238 5x SP

Location

Loc Qty

Loc Code

ST434

4

76439

4

D2747

Manufactured No

110 Each 26.0000 4

D2747

Set Screw

**

B 77484 2420 SP

Location

Loc Qty

Loc Code

ST021

26

73495

26

12-02-06

December-13-11 4:31:38 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December-13-11 4:31:38 PM

Page 4

Work Order ID: 77619

77619

Parent Item: K10003

K10003

Parent Item Name: Saddle, D205-634-011

Start Date: 13/12/2011

Required Date: 05/01/2012

Start Qty: 6.00

Required Qty: 6.00

D2876 Manufactured No

110 Each 87.0000 2 - 12/10

**

SS *D2876*
Saddle Spacer

Location Loc Qty Loc Code

ST025 87

73308 7

76949 80

D2877 Manufactured No

110 Each 37.0000 2 10x
12/10

**

SS *D2877*
Saddle Spacer

Location Loc Qty Loc Code

ST025 37

73309 37

D3405-041 Manufactured No

110 Each 7.0000 1 65

**

SS *D3405-041*
Lug Assembly

Location Loc Qty Loc Code

ST478 7

62227 2

76218 5

D3405-043 Manufactured No

110 Each 11.0000 1 65

**

SS *D3405-043*
Lug Assembly

Location Loc Qty Loc Code

ST423 2

65703 2

ST478 9

76221 9

D3407-041 Manufactured No

110 Each 0.0000 1 65

**

SS *D3407-041*
Tow Ring

December-13-11 4:31:38 PM

Shop Packet Print

Page 4

SS
10x
12/10
B77052 10x SP
65
B77686 SP
5x
65
B76999 1x
B77685 4x
65
B77618 SP
12-02-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December-13-11 4:31:38 PM

Work Order ID: 77619

77619

Parent Item: K10003

K10003

Parent Item Name: Saddle, D205-634-011

Start Date: 13/12/2011

Required Date: 05/01/2012

Start Qty: 6.00

Required Qty: 6.00

D3417-5

Manufactured No

110

Each

25.0000

2

**

D3417-5

Washer

Location

Loc Qty

Loc Code

ST053

25

73326

1

75044

24

D3456-1

Manufactured No

110

Each

45.0000

1

**

D3456-1

Washer

Location

Loc Qty

Loc Code

FG

7

25701

7

ST054

38

66848

3

71165

2

73493

33

D3533-1

Manufactured No

110

Each

34.0000

2

**

D3533-1

Set Screw

Location

Loc Qty

Loc Code

ST065

34

73310

34

~~1000~~

12/10

B776084 SP

65

SP B77486 \$x.

10

B776011

SP 12-02-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 6

December-13-11 4:31:38 PM

Work Order ID: 77619

77619

Parent Item: K10003

K10003

Parent Item Name: Saddle, D205-634-011

Start Date: 13/12/2011

Required Date: 05/01/2012

Start Qty: 6.00

Required Qty: 6.00

MS21042L4

Purchased

No

110

Each

9,264.000

24

**

144120

SP

MS21042I 4

Nut

Location

Loc Qty

Loc Code

ST300

9264

117441

51

117601

342

118451

133

119017

3738

119075

5000

111120x

MS21043-4

Purchased

No

110

Each

1,361.000

5

**

25

SP 12-02-06

MS21043-4

Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST300

470

118686

470

ST301

851

119309

352

119546

499

25x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.0 PARTS LIST

Item	634 -011	634 -015	634 -041	634 -045	641 -011	Part Number	Description
	X					D205-634-011	SKIDTUBE INSTALLATION (STANDARD)
		X				D205-634-015	SKIDTUBE INSTALLATION (MODIFIED)
	1		X			D205-634-041	SKIDTUBE
		1		X		D205-634-045	SKIDTUBE
	1	1			X	D205-641-011	GROUND HANDLING KIT
1			1			D2580-041	205 SKIDTUBE ASSEMBLY (STANDARD)
1				1		D2580-045	205 SKIDTUBE ASSEMBLY (MODIFIED)
2A			16	16		D2594-1	* PLUG
2B			16	16		D2594-3	* O-RING
3			1	1		D2855	* AFT CAP
4			2	2		AN3-5A	* BOLT
5			2	2		NAS1149D0332J	* WASHER (AN960JD10L)
6A			1	1		D3564-9	* WEARSHOE (REPLACES D2577-1)
6B			1	1		D3566-1	* GASKET
7A			1	1		D3564-11	* WEARSHOE (REPLACES D2577-3)
7B			1	1		D3566-1	* GASKET
8A			1	1		D3564-5	* WEARSHOE (REPLACES D2577-5)
8B			1	1		D3566-5	* GASKET
9A			1	1		D3564-13	* WEARSHOE
9B			1	1		D3566-13	* GASKET
10			50	50		AN3C4A	* BOLT (REPLACES AN3-4A)
11			50	50		NAS1149C0332R	* WASHER (AN960C10L)
12			50	50		ALS4-1032-130	* INSERT
13			2	2		ALS4-1032-225	* INSERT
20	1	1				D2571	SADDLE, FWD OUTSIDE
21	1	1				D2572	SADDLE, FWD INSIDE
22	1	1				D2573	SADDLE, AFT OUTSIDE
23	1	1				D2574	SADDLE, AFT INSIDE
24	8	8				AN4-51A	BOLT
25	16	16				D2570	BUSHINGS
26	8	8				MS21042L4	NUT (OR MS21042-4)
27	8	8				AN6-12A	BOLT
28	8	8				NAS1149D0668J	WASHER (AN960JD616)
29	16	16				AN4-6A	BOLT
30	32	32				NAS1149D0463J	WASHER (AN960JD416)
31	16	16				MS21042L4	NUT (OR MS21042-4)
32	4	4				D2747	SET SCREW
33	2	2				D3533-1	SET SCREW
40	1	1				D3407-041	TOW RING (REPLACES D2968-041)
41	1	1				D3456-1	WASHER
43	1	1				MS21043-4	NUT
44	2	2				D3417-5	WASHER
50					1	D3405-041	LUG ASSEMBLY (REPLACES D2736-1)
51					1	D3405-043	LUG ASSEMBLY (REPLACES D2736-3)
52					4	AN4C46A	BOLT
53					8	D2570	BUSHING
54					4	MS21043-4	NUT (OR MS21042-4)
60	2	2				D2876	SADDLE SPACER
61	2	2				D2877	SADDLE SPACER

*DENOTES THAT PART IS INCLUDED WITH D2580-041/-045 ASSEMBLY ABOVE

• COPYRIGHT © 1996 BY DART AEROSPACE LTD •
 THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED
 OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: G

Date: 11.06.24